

Shp May 6

EUROCOPTER

Work Order ID 67703

Tuesday, March 29, 2011 1:05:48 PM



Item ID: D350-591-311	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Heli-Access-Step, Long LH				
Start Date: 3/29/2011	Start Qty: 5.00		Cust Item ID:	
Required Date: 5/6/2011	Req'd Qty: 5.00		Customer:	

Reference:

Approvals:	Process Plan:	Date: 11-03-29	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3272	Rev B								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-311 CHG001								

Handwritten notes: BG 11-5-5, 05, 06, 5

110		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/R Aluminum Rod								
	3-Grind End Plate flush								

Handwritten notes: 11.04.29, 25, 0

Handwritten notes: M114703, M115928

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds

0.00

Memo

0.00

5 0 BE11/04/29

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5 11/04/29

x5 41

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4 1

0.00

Memo

0.00

K.

5 0 11.04.29

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
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Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft-End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod ☒ M114703

6-Grind End Plate flush

7-Install last rivet as per Dwg.

11.04.29

5 0

11.05.02

5 0

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Required Date: 5/6/2011 Req'd Qty: 5.00

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Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC10- Inspect visual per QS1004- ground welds

0.00



QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing



Setup Start



Stop



Run Start



Stop



S 11/05/04

S 11/05/04

x5

LH

SXLH

= 7 m.p

11/05/04

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Setup Start



Revision ID:

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:50
320 °F
10:20

0.00

m-l 11/05/05

5XLH

230

Wing Walk as per dwg QSI005 4.4 Batch M11730105

0.00



HandFinish

Hand Finishing

Memo

0.00

15LH / 11 05 05 05

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

m 11 05 05 05

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 Packaging Packaging	Pick Kit Memo	0.00 0.00					11/5/4		SP 50
260 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00					11	05 06	(5)
270 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD350-591-311 Location: _____	0.00 0.00		ReoB				4/10/6	(5)

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/6/9-10
MK
11-05-06

Picklist Print

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Page 1

Work Order ID: 67703

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 		Manufactured	No			110	Each	0.0000	1	5			
Step D3067-1 		Manufactured	No			110	Each	69.0000	1	5			
End Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA016	<u>367582</u>	69				5			
					65969	69							
D3219-1 		Manufactured	No			110	Each	56.0000	2	10			
Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA017	<u>368202</u>	56				10			
					66133	56							
D3066-1 		Manufactured	No			180	Each	53.0000	2	10			
Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA015	<u>367581</u>	53				2			
					66131	53							
					<u>368337</u>								

11.04.25 B67708 (5)

11.04.28

5

11.04.28

10

11.04.29

2

Picklist Print

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Page 2

Work Order ID: 67703

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 5.00

Required Qty: 5.00

MS20600-AD4W4

Purchased

No

180

Each

1,600.000

16

80



Rivets

Location

Loc Qty

Loc Code

ST321

1500

116188

1500

WA018

100

116712

100

D3065-041

Manufactured

No

180

Each

47.0000

1

5



Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA014

367503

47

66149

27

66808

20

D3067-1

Manufactured

No

180

Each

69.0000

1

5



End Plate

Location

Loc Qty

Loc Code

WA016

367582

69

65969

69

AN3-35A

Purchased

No

250

Each

75.0000

2

10



Bolt

Location

Loc Qty

Loc Code

ST353

75

116191

75

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Shop Packet Print

Page 2

Picklist Print

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 5.00

Required Qty: 5.00

D3235-1 Manufactured No

250 Each

67.0000 2 10



Mounting Lug



B67831

[Signature]

Location

Loc Qty

Loc Code

ST471

67

65073

7

66941

60

D3278-041 Manufactured No

250 Each

55.0000 1



Support Assembly



B67584

[Signature]

Location

Loc Qty

Loc Code

ST471

55

66155

15

66946

40

AN960JD416 NAS1149D0463J Purchased No

250 Each

0.0000 16 80



Washer



M117291

[Signature]

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000 4 20



Washer



M117291

[Signature]

ANS-36A Purchased No

250 Each

97.0000 2 10



Bolt



M117366

[Signature]

Location

Loc Qty

Loc Code

ST341

97

116704

97

Picklist Print

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 5.00

Required Qty: 5.00

ml
X5
D2618
Bushing

Manufactured No

250 Each

94.0000

2 10



B68249

[Signature]

Location

Loc Qty

Loc Code

ST019

94

66942

94

250 Each

27.0000

4 20



B67827

[Signature]

ml
X5
D2230-3
Lug

Manufactured No

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST470

27

66936

27

250 f

25.5200

1.2 6



B68076

[Signature]

ml
X5
D2856-400
Abrasion Strip

Manufactured No

Location

Loc Qty

Loc Code

ST409

25.52

63735

25.52

250 Each

2,189.000

2 10



11/5/4

[Signature]

ml
X5
*** cut (2) at 7.20" (D2856-400-720) ***
MS21042L3
Nut

Purchased No

Location

Loc Qty

Loc Code

ST300

2189

116391

589

116540

800

116549

800

10

Picklist Print

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Work Order ID: 67703

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 5.00

Required Qty: 5.00

AN4-13A

Purchased

No

250

Each

336.0000

8

40



Bolt

Location

Loc Qty

Loc Code

ST357

336

116786

36

117094

300

MS21042L5

Purchased

No

250

Each

941.0000

2

10



Nut

Location

Loc Qty

Loc Code

ST300

941

115594

181

116105

500

116548

260

MS21042L4

Purchased

No

250

Each

3,324.000

8

40



Nut

Location

Loc Qty

Loc Code

ST300

3324

116188

1324

116823

2000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

20



Washer



DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04-*H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *67703*

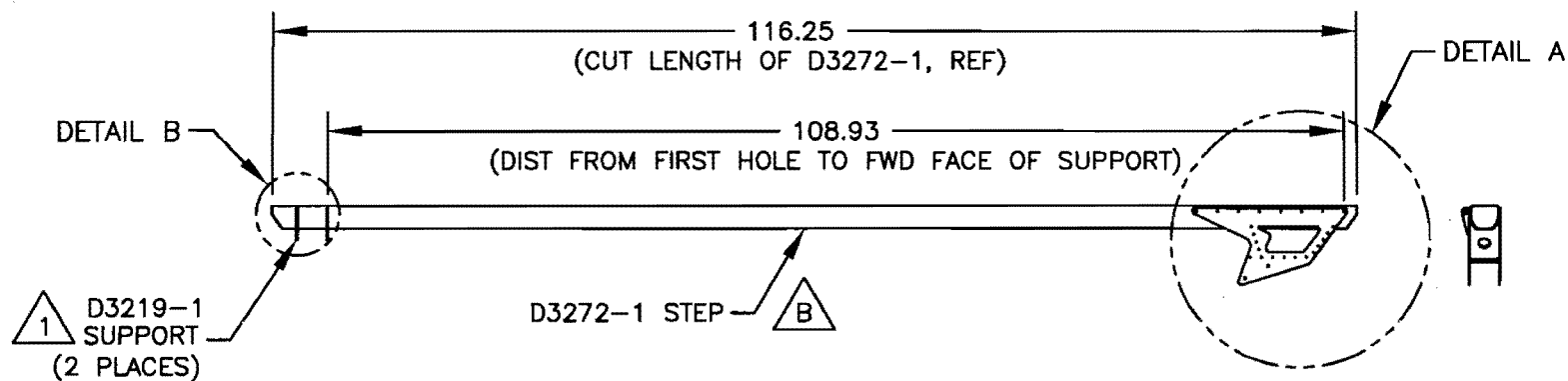
0711-03-22

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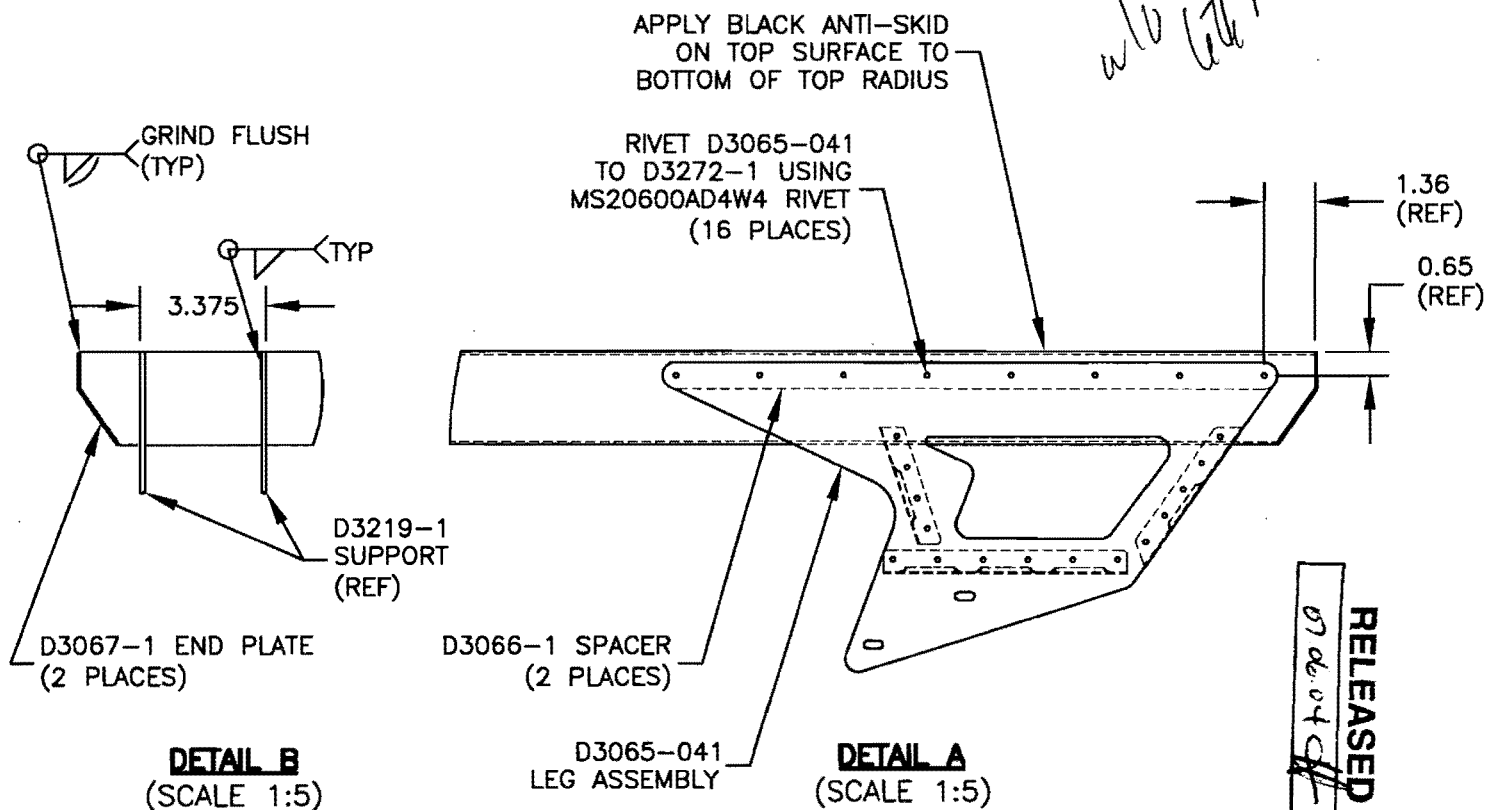
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DESIGN	q	DRAWN BY	J	DART AEROSPACE LTD
CHECKED	CE	APPROVED	J	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DETAIL B
(SCALE 1:5)

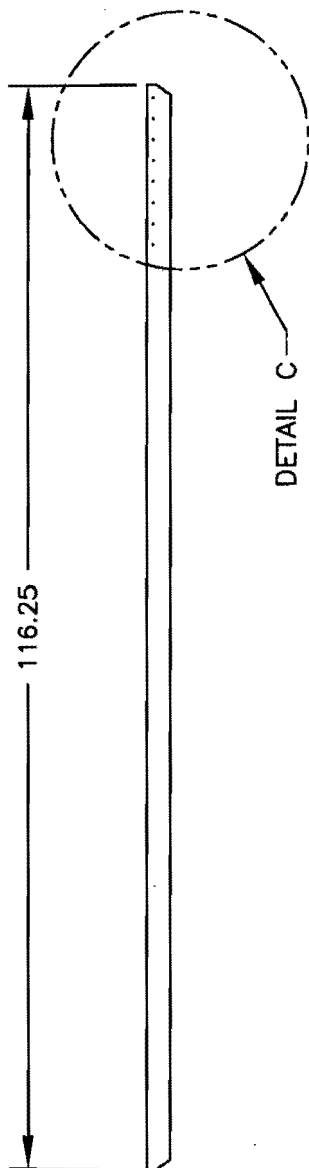
DETAIL A
(SCALE 1:5)



DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

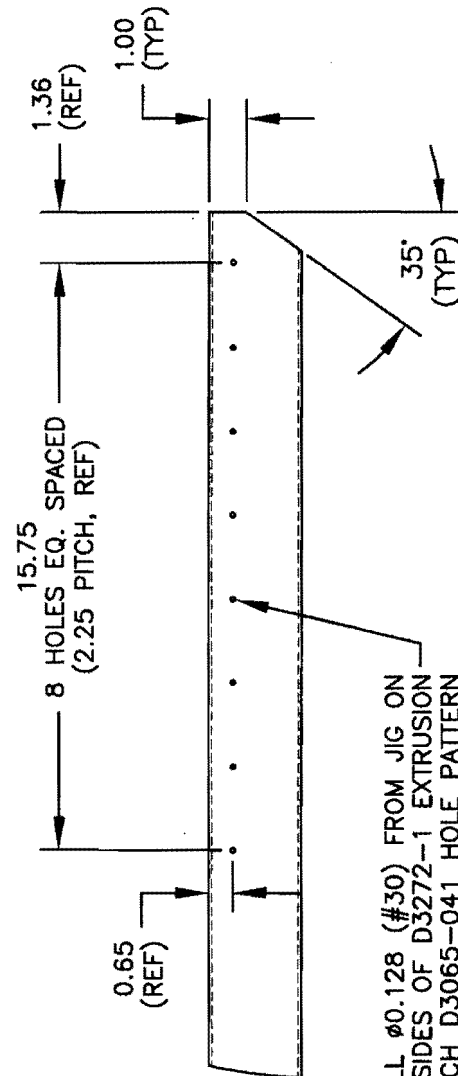
07.06.04 *[Signature]*



DETAIL C

W/C 67703

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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